

Work Order ID 78993

78993

Page 1

January-18-12 8:38:25 AM

Item ID: D2144

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Bracket

Start Date: 18/01/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: M L J

Date: 12/01/18 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2144

Rev D

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2144 Dwg Rev: D Prog Rev: D 2-
Deburr if necessary

354.063

B12-2-22

(22)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-22

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12 02 22 (22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							
Small Fab	Memo Deburr if necessary	0.00		N/A					
140 *140* Brake NC	NC BRAKE	0.00		SF 12/22/27					
Brake NC	Memo Form as per Dwg D2144Rev: <u>1</u>	0.00				(22)			
150 *150* QC	QC5- Inspect part completeness to step on W/O	0.00		S 12/22/27					
Quality Control	Memo	0.00				(72)			

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Accept

N900040100

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Stop *NS2*

Start Date: 18/01/2012 **Start Qty:** 20.00

20

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Required Date: 01/02/2012 **Req'd Qty:** 20.00

20

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

160

Large Fab

0.00

Large Fab

Memo

Large Fab

1- Weld corner as per Dwg D2144 & QSI 0042- Grind flush

170

QC9- Inspect visual per QSI004- Fusion Welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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 Required Date: 01/02/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <u>7h30</u> <u>8h00</u> FINISH TIME: <u>700°F</u>	0.00 0.00							<u>22x</u> <u>Q</u> <u>SP</u> <u>12/03/28</u>
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<u>22x</u> <u>Q</u> <u>SP</u> <u>12/03/25</u>
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: <u>SLS</u> Memo	0.00 0.00							<u>22x</u> <u>SP</u> <u>12-03-30</u>

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

12/3/30
CL12/03/30

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January-18-12 8:38:29 AM

Page 1

Work Order ID: 78993

78993

Parent Item: D2144

D2144

Parent Item Name: Hinge Bracket

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: D04.05.06ReformatKJ/RF

IPP Rev:E Now on Waterjet 06-10-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			120	sf	141.8300	0.0945	1.89			

M304S16GA

304/316 Sheet .063

IB12-2-22

Location

Loc Qty

Loc Code

MAT020

141.83

119346

5.5

119653

40.33

120243

96

119653

~~120243~~

22

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	78993
Description: Hinge Bracket		Part Number:	D2144
Inspection Dwg: D2144 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.379	2		V B/L	
3.022	+/-0.010	3.028	2		V	
2.468	+/-0.010	2.471	2		V	
1.913	+/-0.010	1.916	2		V	
1.555	+/-0.010	1.557	2		V	
4.126	+/-0.010	4.128	2		V	
3.465	+/-0.010	3.460	2		V	
0.340	+/-0.010	.338	2		V	
0.625	+/-0.010	.623	2		V	
1.000	+/-0.010	.999	2		V	
1.083	+/-0.010	1.083	2		V	
1.660	+/-0.010	1.663	2		V	
2.312	+/-0.010	2.309	2		V	
2.844	+/-0.010	2.844	2		V	
3.294	+/-0.010	3.294	2		V	
Ø0.257	+0.006/-0.001	.259	2		V	
Ø0.171	+0.005/-0.001	.171	2		V	
Ø0.320	+0.006/-0.001	.319	2		V	
0.354	+/-0.010	.352	2		V	
0.063	+/-0.010	.061	2		V	

Measured by: B	Audited by: m/w	Prototype Approval:	N/A
Date: 12-2-22	Date: 12/2/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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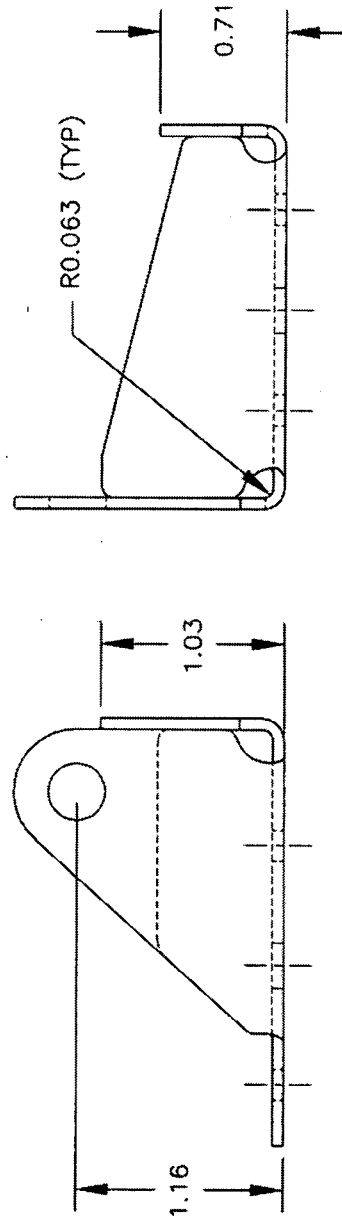
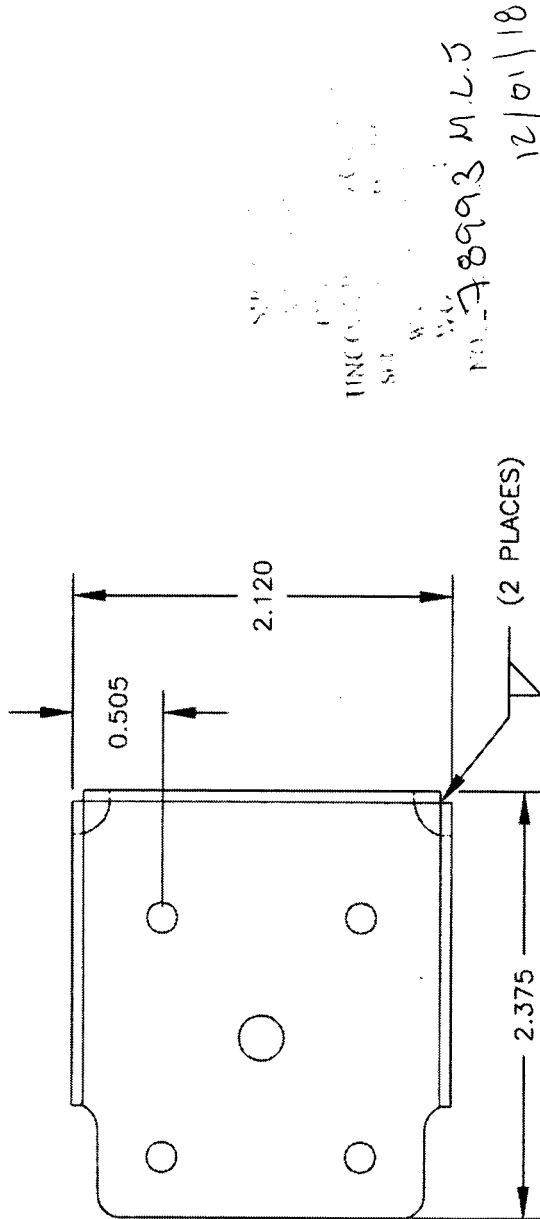
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DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DA	APPROVED CA	DRAWING NO. D2144	REV. D SHEET 1 OF 2
DATE 98.10.08	TITLE HINGE BRACKET		SCALE 1:1
A	95.03.17	NEW ISSUE	
C	96.06.05	FLAT PATTERN LAYOUT ADDED	
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)	

RELEASED
98.10.15 KE



FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004

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RELEASED
98.10.15 K6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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